

Date: Wednesday, 1/4/2006 2:36:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET LID
Job Number : 25389B	
Estimate Number : 11274	
P.O. Number : N/A	Part Number : D2252043
This Issue : 1/4/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW D2252 REV. E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 23136B	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/30/2006 Qty: 1 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment : Est Rev:1 REVISED AS PER REV E 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100003 06/03/08		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- Cut D2252-1-3-9 as per Dwg D2252 2-Drill hole in D2252-1 as per Dwg D2252 3-Deburr & Remove all Markings from Material 06/03/08 ①		
3.0	D2329	Label Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2329 Label Plate B23490 06/03/13 ①		
4.0	D23271	Spacer Bushing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2327-1 Bushing B24873 06/03/08 ①		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:36:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 25389B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B23445

②
M 06/03/08

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

B25824

②
M 06/03/13

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf

M304EX0.75-16F Expanded Metal

M100230

1890'
M 06/03/13

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch:

M19555

①
M 06/03/08

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 03-06-16

①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 06/03/16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:36:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 25389B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①
20.03.17

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 206/03/20 ①

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
DP 06/03/23

Job Completion



u 06.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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05.11.26

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

E

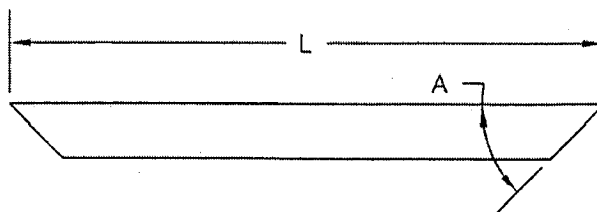
E

E

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50 ✓	45
2		D2252-3	FRAME	96.00 ✓	45
	2	D2252-7	FRAME	24.00 ✓	90
1		D2252-9	FRAME	10.25 ✓	90
1		D2252-11	FRAME	25.00 ✓	90
1		D2252-13	FRAME	42.00 ✓	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78 ✓	53
	2	D2252-19	FRAME	95.27 ✓	45
	2	D2252-21	FRAME	30.82 ✓	90
	1	D2252-23	FRAME	30.62 ✓	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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SUBJECT TO
WITH 10

25389B

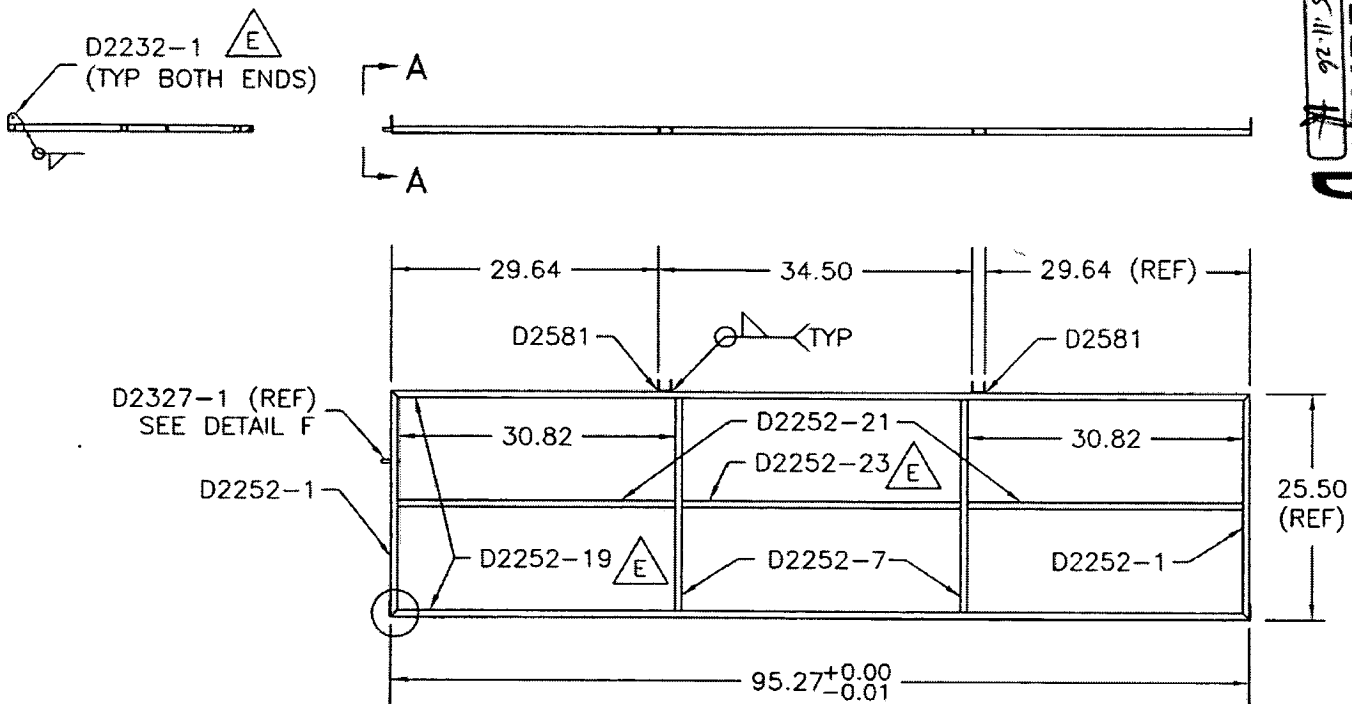
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		TITLE	BASKET ASSEMBLY (206L)	SHEET 2 OF 5
				SCALE
				NIS

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05.11.26 *[Signature]*



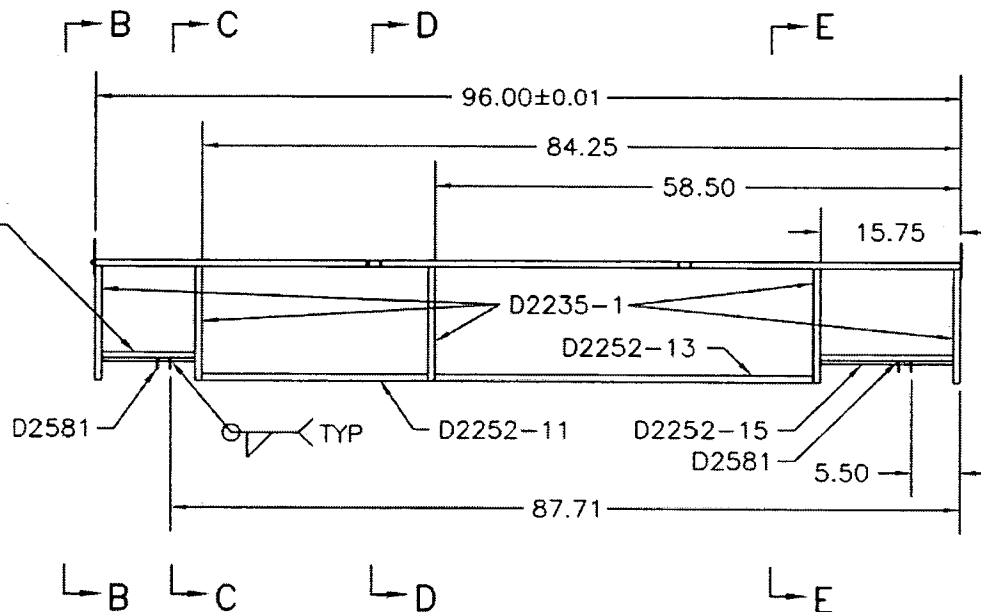
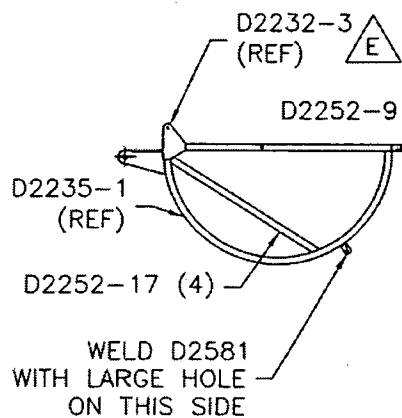
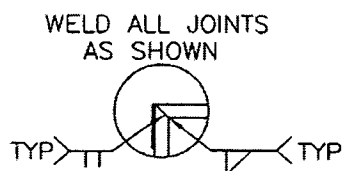
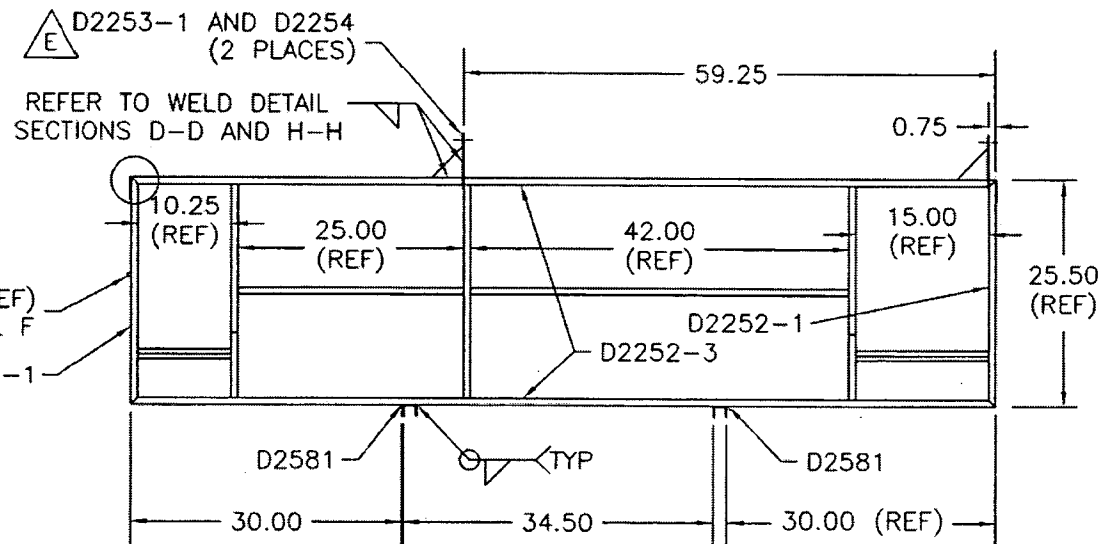
D2252-043 LID FRAME

[Welding symbol]
WELD ALL JOINTS
AS SHOWN

ORDERED
TO ASSEMBLY
NOT NOTICE
ROLLED COPY
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DATE	05.11.10	TITLE	D2252	SHEET 3 OF 5
			BASKET ASSEMBLY (206L)	SCALE
				NIS



D2252-041 BASKET FRAME

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05.11.26

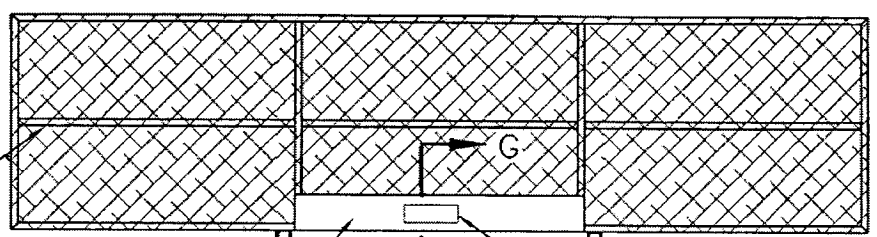
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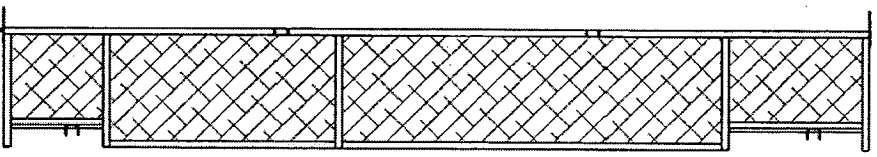
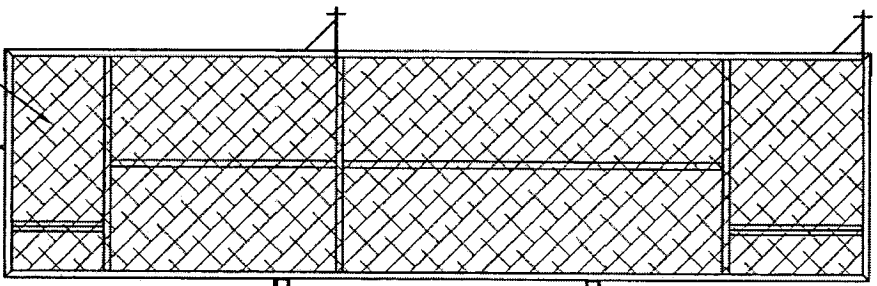
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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5
		SCALE	NIS	



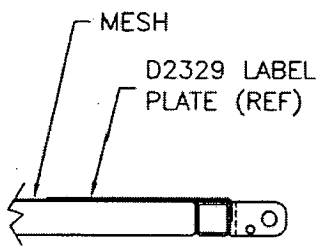
D2252-043 LID ASSEMBLY

D2329 LABEL PLATE CENTER ON THE BASKET LID

REMOVE 2" X 6" SECTION OF MESH FROM BEHIND LABEL PLATE



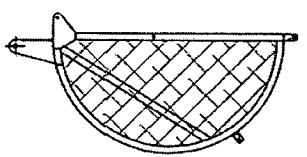
D2252-041 BASKET ASSEMBLY



SECTION G-G



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

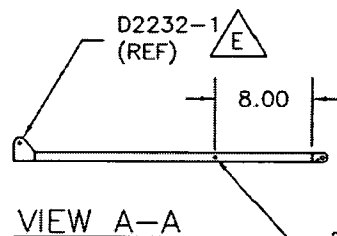
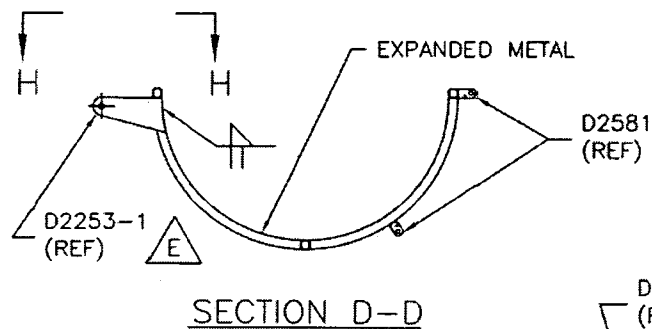
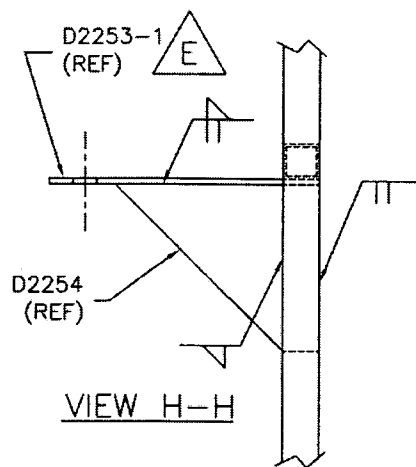
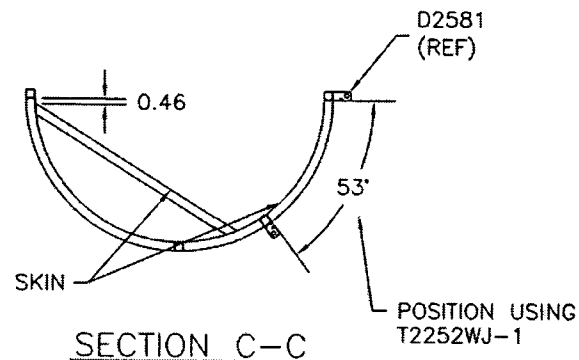
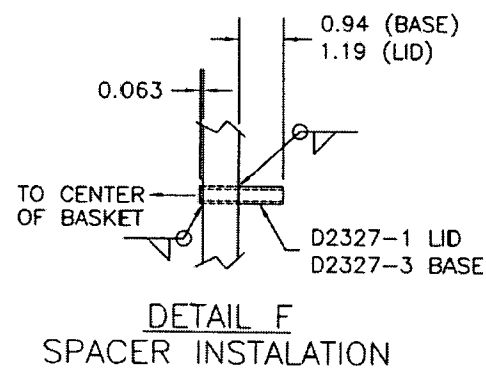
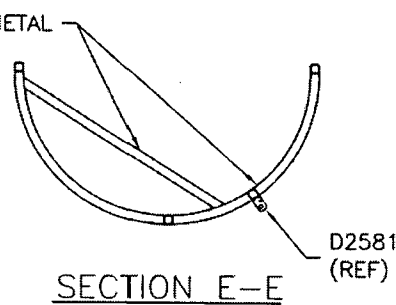


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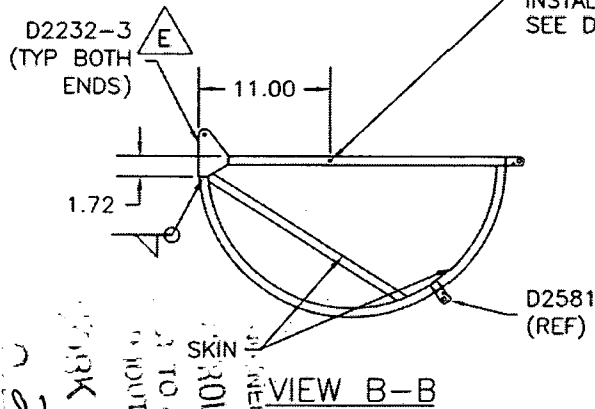
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DATE	05.11.10	DRAWING NO.	D2252	SHEET 5 OF 5
		TITLE	BASKET ASSEMBLY (206L)	SCALE
				NTS



DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL F



RELEASED
05.11.26

WORK ORDER
25883B

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